Work Order ID 52117

September 16, 2009 1:11:33 PM

Item ID: D209-669-043 **Accept** **Setup Start** **Stop**

Revision ID: B

Item Name: Replacement Skidtube

Start Date: 09/16/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 09/30/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** MMF **Date:** 09-09-16 **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2906	Rev B								
100		0.00							
DC	DOCUMENT CONTROL								
Document Control	**Memo** Photocopy D209-669 bluefile & type labels per PPP D205-669-043 Chg 002	0.00							
110		0.00							
Skidtubes	Skidtubes								
Skidtubes	**Memo** 1- Inspect mat'l D2500-1-190 for damage 2-Cut D2500-1-190 per Dwg D2906 if necessaryDeburr ends 3-Acid etch and Alodine tube per QSI 005 4.1	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 52117

September 16, 2009 1:11:33 PM

Item ID: D209-669-043
Revision ID: B
Item Name: Replacement Skidtube

Start Date: 09/16/2009 **Start Qty:** 1.00
Required Date: 09/30/2009 **Req'd Qty:** 1.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									

DP
9-9-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Revision ID: B

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Required Date: 09/30/2009 **Req'd Qty:** 1.00 **Customer:**

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Skidtubes	Skidtubes								
Skidtubes	**Memo**	0.00							

Skidtubes

1-Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid) > MB 09-09-22

2-Open holes to 0.500" as per Dwg D2906 without cutting fluid

3-Countersink holes as per Dwg D2906 without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M112391

Sikaflex expire date: 10-02-10

Start Time: 7:30 Date: 09-09-22

Fin Time: 1120AM Date: 9-9-23

pick:

Qty	P/N	description	B/N
1	D2926-3	Web	B-52065

MB 09-09-22

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
CNC Bend 1	BENDING MACHINE - CROSSTUBES								
CNC Delta 100 Bender	**Memo**	0.00							
	1-Bend as per program COB43FWD & COBRAFT on CNC Bender and Folio FT								
	2-Cut tubes as per Dwg. D2906 & per template DT8185B & DT8185BC								
150		0.00							
Skidtubes	Skidtubes								
Skidtubes	**Memo**	0.00							
	1-Cut tube as per dwg and ensure ends are perpendicular to ridge N/A								
	2-Deburr ends BE 09/09/23								
	3-Prepare tube for welding, remove alodine as required. BE 09/09/23								
160	QC5- Inspect part completeness to step on W/O	0.00							
QC									
Quality Control	**Memo**	0.00							

4-9-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
Skidtubes	Large Fab								
Skidtubes	**Memo**	0.00							

1-Weld crossbolt spacers D2579 as per Dwg. D2906 and QSI 004.
For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod MIII999 BE 09/09/23

2-Grind welds as per Dwg D2906 Grind flush ridge made from bending

3-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web.Deburr > DP 9-9-26

4-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2906, Deburr holes

5-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Deburr

6-Drill pilot holes for Tow ring using DT8091-3 , open to .640"and Deburr) — AWM 9-9-29

180	QC10- Inspect visual per QSI004- ground welds	0.00							
QC									
Quality Control	**Memo**	0.00							

2) S 09/09/30 (K) 9

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W/O:		WORK ORDER CHANGES					
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Run Start **Stop**

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	=> Sarlar130			XL	ø		
200 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 **Memo**	0.00 0.00	=> ML 09/16/01			XL	ø		
210 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum MM122760 **Memo** START TIME: 8:30am OVEN TEMPERATURE: 320°F FINISH TIME: 9:00am	0.00 0.00	ML 09/10/01			XL	ø		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Work Order ID 52117

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Run Start **Stop**

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC3- Inspect Part Finish	0.00	BR 09-10-01			D.			
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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Work Order ID 52117

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Start Date: 09/16/2009 **Start Qty:** 1.00 **Cust Item ID:**

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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00				X1			
HandFinish	HandFinishing								
Hand Finishing	**Memo**	0.00							

1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐☐☐ Sikaflex-291 ☐ M112391
Sikaflex expire date: 10/20

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906

3-Inspect for foreign object per QSI 024

4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐☐ Sikaflex-291 ☐ M112391
Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2906 and QSI 005 4.4
Batch: M112106

MD 09/10/01

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Work Order ID 52117

September 16, 2009 1:11:33 PM

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Revision ID: B

Item Name: Replacement Skidtube

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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
250	Packaging	0.00							
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPPD209-669-043 Location: PPP Rev: PPP 52143								
260	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

2) Sat 10/02

(2) 0

C 9/10/05 (1)

09/10/05

09-10-5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

September 16, 2009 1:11:33 PM

Work Order ID: 52117

Parent Item: D209-669-043RevB

Parent Item Name: Replacement Skidtube

Start Date: 09/16/2009 **Required Date:** 09/30/2009

Comments:

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-1-190RevU/R		Manufactured	No			110	Each	0.0000	1.0000			
Ext'n - 'I' Beam Tube 4"										B-50146	MB 09-09-23	
D2926-3RevA		Manufactured	No			110	Each	1.0000	1.0000			
Web										B- 52065	MB 09-09-23	

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	1		
46846	1		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			170	Each	284.0000	19.0000			
Crossbolt Spacer												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	284		
43988	4		
46434	4		
46956	2		
47797	9		
48272	2		
51314	100		
51315	163		

B51525 (19) BB 09/09/23

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Work Order ID: 52117

Parent Item: D209-669-043RevB

Parent Item Name: Replacement Skidtube

Start Date: 09/16/2009 **Required Date:** 09/30/2009

Comments:

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2855RevA		Manufactured	No			230	Each	15.0000	2.0000			
Cap												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse	50770	
FP6	15	
50513	15	

AN3-5A		Purchased	No			230	Each	2,461.000	4.0000			
Bolt												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	2461	
100188	192	
105057	2243	
15205	26	

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Parent Item Name: Replacement Skidtube

Start Date: 09/16/2009 **Required Date:** 09/30/2009

Comments:

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L		Purchased	No			230	Each	6,485.000	4.0000			
Washer												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	6485		_____	
101291	16		_____	
104885	153		_____	
105793	236		_____	
109632	1080		XC	MD 09/10/01
110985	5000		_____	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			230	Each	3,348.000	44.0000			
Insert												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	3348		_____	
105855	16		_____	
108606	52		_____	
111529	1488		_____	
111779	1792		XYY	MD 09/10/01

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52117

Parent Item: D209-669-043RevB

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 09/16/2009 **Required Date:** 09/30/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A		Purchased	No			230	Each	400.0000	44.0000			
BOLT												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse	12,720	
ST	400	
112082	14	
112314	140	
112612	246	

x44 mo 09/10/09

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L		Purchased	No			230	Each	6,964.000	44.0000			
washer												

Warehouse Location	Loc Qty	Loc Code
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	6864	
112116	1864	
112612	5000	

x44 mo 09/10/09

Dart Aerospace Ltd

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

September 16, 2009 1:11:33 PM

Work Order ID: 52117

Parent Item: D209-669-043RevB

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 09/16/2009 **Required Date:** 09/30/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3RevC		Manufactured	No			230	Each	864.0000	14.0000			
O-Ring, 205 Skidtube												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
FP	500	
51613	500	
Main Warehouse		
ST	364	
27168	44	
29908	320	

X14 MD 09/10/01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-1RevC		Manufactured	No			230	Each	1,121.000	14.0000			
Plug, 205 Skidtube												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	1121	
42221	16	
42807	92	
43884	3	
46435	2	
47251	83	
51527	100	
51757	825	

X14 MD 09/10/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

September 16, 2009 1:11:33 PM

Work Order ID: 52117

Parent Item: D209-669-043RevB

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 09/16/2009 **Required Date:** 09/30/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-9RevD		Manufactured	No			230	Each	45.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
FP19	40			
51675	40		X1	MD 09/10/01
Main Warehouse				
ST	5			
44659	1			
45825	1			
51258	3			

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-11RevD		Manufactured	No			230	Each	15.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
FP	13		X1	MD 09/10/01
51256	13			
Main Warehouse				
ST	2			
45823	1			
50112	1			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

September 16, 2009 1:11:33 PM

Work Order ID: 52117

Parent Item: D209-669-043RevB

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 09/16/2009 **Required Date:** 09/30/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-5RevD		Manufactured	No			230	Each	47.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code	
OFFSHORE			
FG	2		_____
34806	2		_____
Main Warehouse			
FP19	43		_____
51257	2		_____
(51655)	41		X1 mo 09/10/01
Main Warehouse			
ST	2		_____
45824	1		_____
47433	1		_____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

September 16, 2009 1:11:33 PM

Work Order ID: 52117

Parent Item: D209-669-043RevB

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 09/16/2009 **Required Date:** 09/30/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-1RevC		Manufactured	No			230	Each	49.0000	2.0000			
Gasket												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse	52313		x2 MD 09/10/10
FP	39		
51612	23		
51912	16		
Main Warehouse			
ST	10		
46349	1		
47434	2		
51218	1		
51259	6		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-5RevC		Manufactured	No			230	Each	55.0000	1.0000			
Gasket												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
FP	12		_____
51929	12		_____
Main Warehouse			
FP19	36		_____
51669	36		X1 MD 09/10/01
Main Warehouse			
ST	7		_____
36113	1		_____
46186	1		_____
47318	1		_____
51260	4		_____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

#52117

	QTY -041	QTY -043	Part Number	Description
	X		D2906-041	SKIDTUBE ASSEMBLY
		X	D2906-043	SKIDTUBE ASSEMBLY
	1	1	D2500-1-190	EXTRUSION
	22	19	D2579	CROSS BOLT SPACER
	12	14	D2594-1	PLUG
	12	14	D2594-3	O-RING
	2	2	D2855	AFT CAP
	1		D2926-1	WEB
		1	D2926-3	WEB
B	1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
B	1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
B	1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
	1		D3564-15	WEARSHOE
	2	2	D3566-1	GASKET
	1	1	D3566-5	GASKET
	1		D3566-15	GASKET
	50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
B	50	44	AN3C4A	BOLT
B	4	4	AN3-5A	BOLT
	50	44	AN960C10L	WASHER
	4	4	AN960JD10L	WASHER

GENERAL NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
7) WELDING TO BE DONE PER DART QSI 004.
8) FINISH:
 ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
10) ALL DIMENSIONS ARE IN INCHES.

RELEASED
07.04.04

REV.	DESCRIPTION	BY	DATE
B	UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22

DESIGN		**DART AEROSPACE LTD**	
DRAWN	CB	**HAWKESBURY, ONTARIO, CANADA**	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.		D2906	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AH-1 (209) SKIDTUBE ASSEMBLY	NTS
DATE	07.08.21		

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

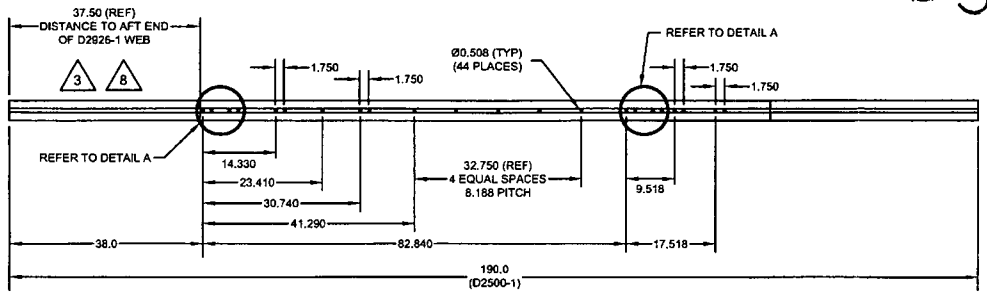
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

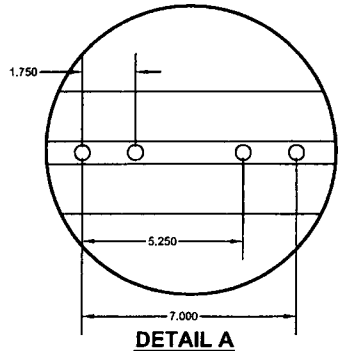
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
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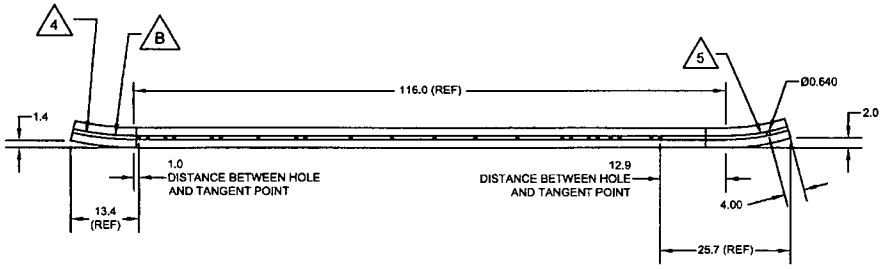
52117



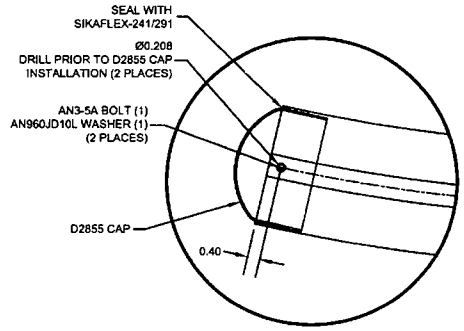
D2906-1 DRILLING DETAIL



DETAIL A
SCALE 1:4

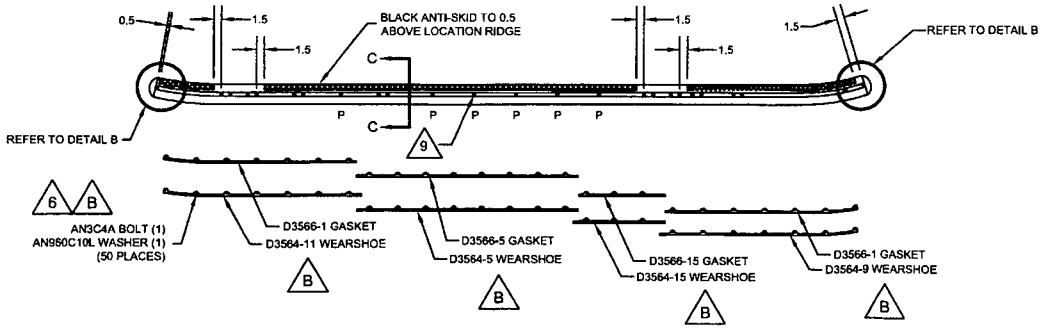


D2906-041 BENDING AND CUTTING DETAIL

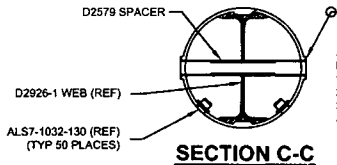


DETAIL B
SCALE 1:4

RELEASED
07.09.04



D2906-041 ASSEMBLY DETAIL



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (22 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

SECTION C-C
SCALE 1:4

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	C.B	
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D2906 SHEET 2 OF 3
APPROVED		TITLE SCALE
DE APPR.		AH-1 (209) SKIDTUBE ASSEMBLY 1:24
DATE	07.08.21	

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52117 #

Dart Aerospace Ltd

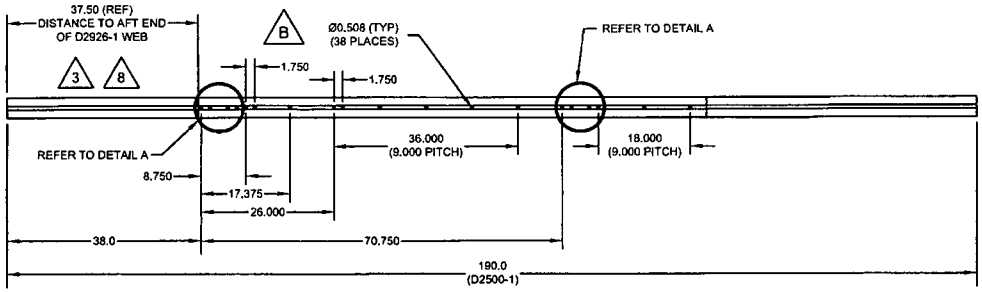
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

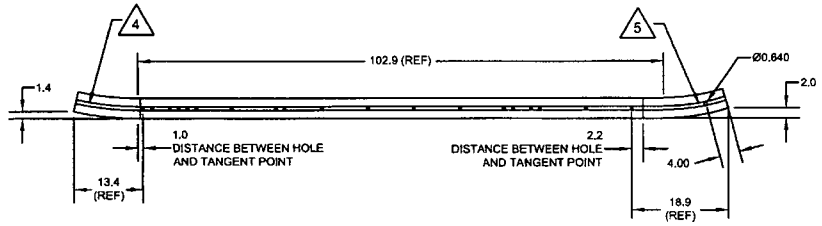
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

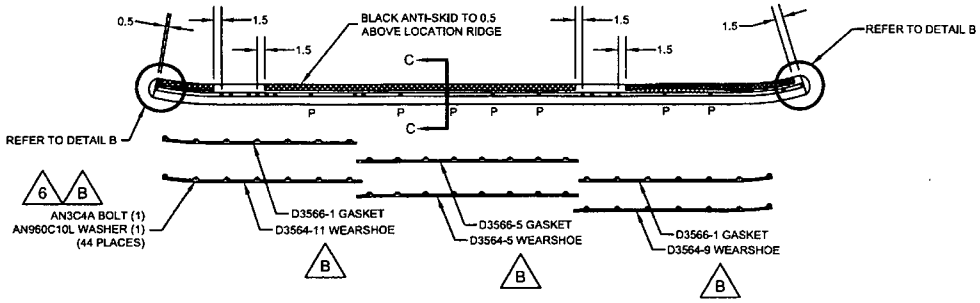
NOTE: Date & initial all entries



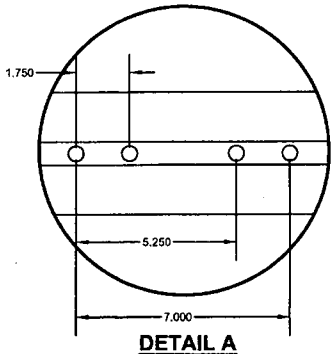
D2906-3 DRILLING DETAIL



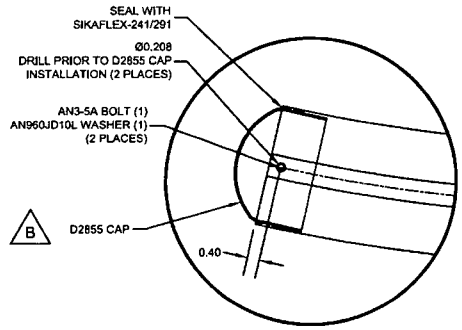
D2906-043 BENDING AND CUTTING DETAIL



D2906-043 ASSEMBLY DETAIL

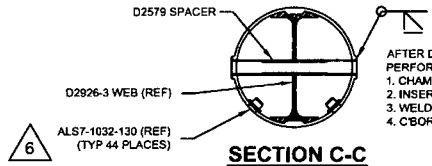


DETAIL A
SCALE 1:4



DETAIL B
SCALE 1:4

RELEASED
07.09.04



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (22 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

SECTION C-C
SCALE 1:4

WIES #

DESIGN		**DART AEROSPACE LTD**	
DRAWN	C.B	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2906	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AH-1 (209) SKIDTUBE ASSEMBLY	1:24
DATE	07.08.21		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

NO. 208

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 52165
Part number: A209-669-043
Description: 209 Skid tube
Welding Process: Tig[✓] Mig[]
Base materiel: Alum
Current: AC[✓] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[✓] fail[]
Penetration:	pass[✓] fail[]

UNACCEPTABLE

Cracks:	pass[✓] fail[]
Undercut:	pass[✓] fail[]
Pin holes:	pass[✓] fail[]
Overlap (cold lap)	pass[✓] fail[]
Porosity (surface):	pass[✓] fail[]
Coloration:	pass[✓] fail[]

Qualifier David Hewitt **Date of Test Coupon** 09/09/23

Welder Barclay Elliott **Date of Test Coupon** 09/09/23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld